

Work Order ID 62962

Thursday, October 14, 2010 12:39:49 PM



Page 1

Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

10-10-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

If D412-742-041 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-041 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 ☒ M11511+

Expiry date: ☐ 11161

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☒ M11511+

Expiry date: ☐ 1110

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R ☐ LPS Procyon ☒ M1114596

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/03/10



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Page 3

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Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-
041 ☐ Location: _____ ☐ PPP Rev: _____

B1D62964

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/03/01

C211103101

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Picklist Print

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Page 1

Work Order ID: 62962

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube



Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP rev D 07.11.01 ecn 1053p EC
 IPP rev E 07.11.27 ecn 1072 EC verified by:DD
 IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:G
 10.02.24 as per ECN10-514 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			110	Each	1,361.000	24	24			
BOLT													

Location	Loc Qty	Loc Code
ST303	3	
115438	3	M116704
ST350	1358	
114108	14	
114416	12	
114523	2	
115300	330	
115589	1000	

AN3C6A		Purchased	No			110	Each	261.0000	12	12			
BOLT													

Location	Loc Qty	Loc Code
ST351	261	
111982	261	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, October 14, 2010 12:39:53 PM

Page 2

Work Order ID: 62962

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No
BOLT

110 Each 110.0000 8

8

11/02/25

Location

Loc Qty

Loc Code

ST351

110

113149

81

x8

114382

29

AN960C10L Purchased No

110 Each 29.0000 44

44



washer

x116304

x44 11/02/25

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C416L Purchased No

110 Each 180.0000 4

4



WASHER x NAS 1149C0432R 1 M116805

x4 11/02/25

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

136

106785

10

107008

10

112828

75

69220

41

D3391-011 Manufactured No

110 Each 0.0000 1

1



Fwd Tube Assembly

B 62971

(x1) 11/02/25

D3391-013 Manufactured No

110 Each 0.0000 1

1



Mid Tube Assembly

B 62972

(x1) 11/02/25

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 62962



Parent Item: D412-742-041



Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3391-015 *pullied on u/s 62972* Manufactured No



Aft Tube Assembly

D3564-1 *✓* Manufactured No



Wearshoe

110 Each 0.0000 1 1

B62974



(x1) 11/02/20

110 Each 14.0000 1 1



11/02/25

Location

Loc Qty

Loc Code

FG

2

33798

2

FP19

12

58823

12

D3564-3 Manufactured No



Wearshoe

110 Each 8.0000 1 1



11/02/25

Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

6

55489

1

58825

5

B62835

11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, October 14, 2010 12:39:53 PM

Page 4

Work Order ID: 62962

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

19.0000

1

1



Wearshoe



YH 11/02/28

Location

Loc Qty

Loc Code

FG

1

B65523

Y1

34806

1

FP19

5

57525

1

58709

1

61699

3

FP-19

13

62237

13

D3566-1

Manufactured No

110

Each

3.0000

2

2



Gasket



YH 11/02/28

Location

Loc Qty

Loc Code

FP015

3

B66129

V2

57715

2

61992

1

D3566-5

Manufactured No

110

Each

17.0000

1

1



Gasket



YH 11/02/28

Location

Loc Qty

Loc Code

FP

5

60869

5

FP015

12

B66146

Y1

62463

12

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Shop Packet Print

Page 4

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Page 5

Work Order ID: 62962

Parent Item: D412-742-041


Parent Item Name: Replacement Float Skidtube


Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00


Required Qty: 1.00


D3591-1 Manufactured No 110 Each 35.0000 2 2

 Bushing

 yl 11/02/28

Location Loc Qty Loc Code

ST072 35
 47121 2
 57350 33


D3672-3 Manufactured No 110 Each 527.0000 4 4

 Phenolic Washer


 yl 11/02/28

Location Loc Qty Loc Code

ST077 527
 47023 16
 57704 511

1364176 x4

MS27039C4-12 Purchased No 110 Each 34.0000 4 4

 SCREW

 yl 11/02/28

Location Loc Qty Loc Code

ST293 34
 114221 34

1117831 x3
yl

Thursday, October 14, 2010 12:39:53 PM

Shop Packet Print

Page 5

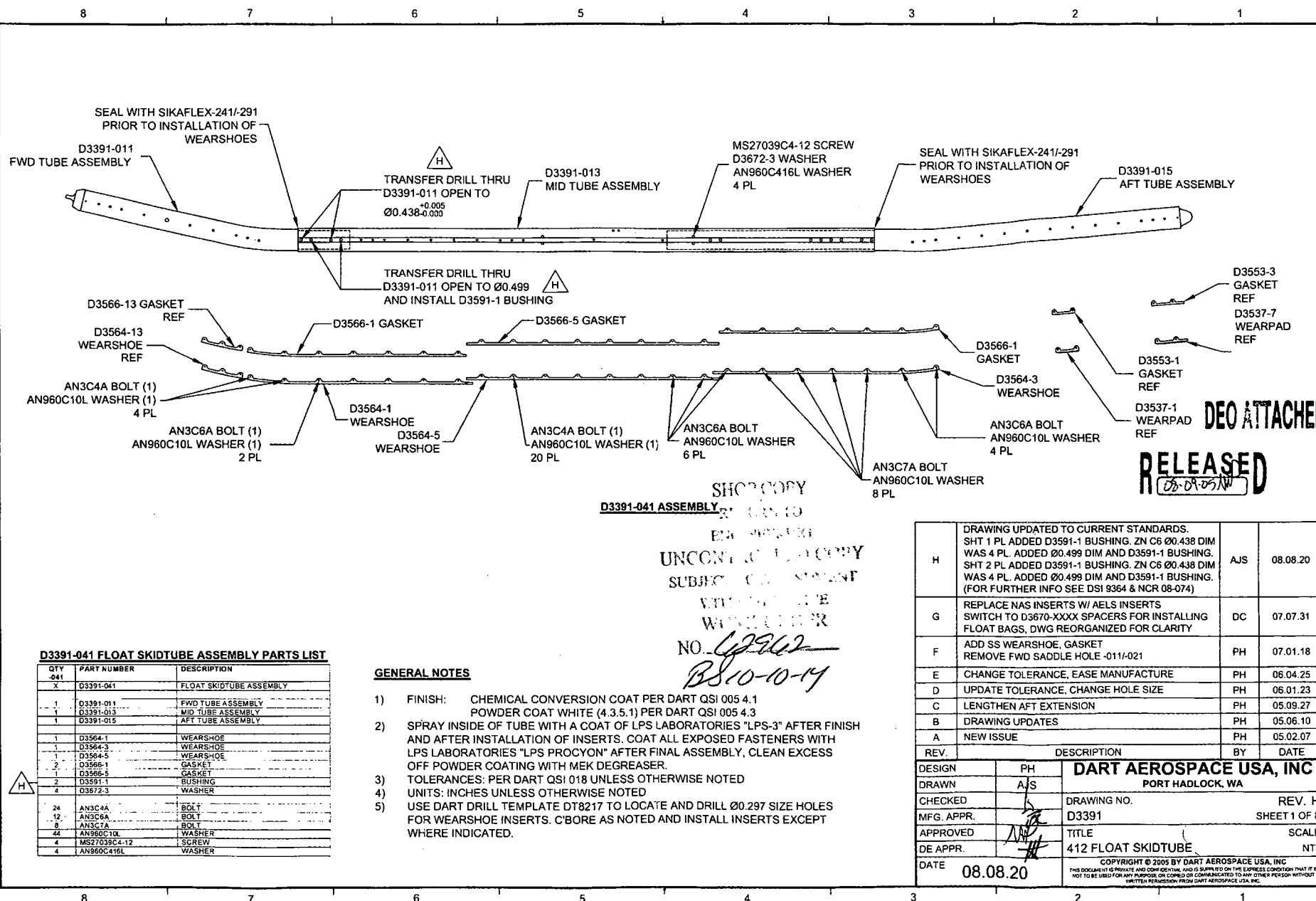
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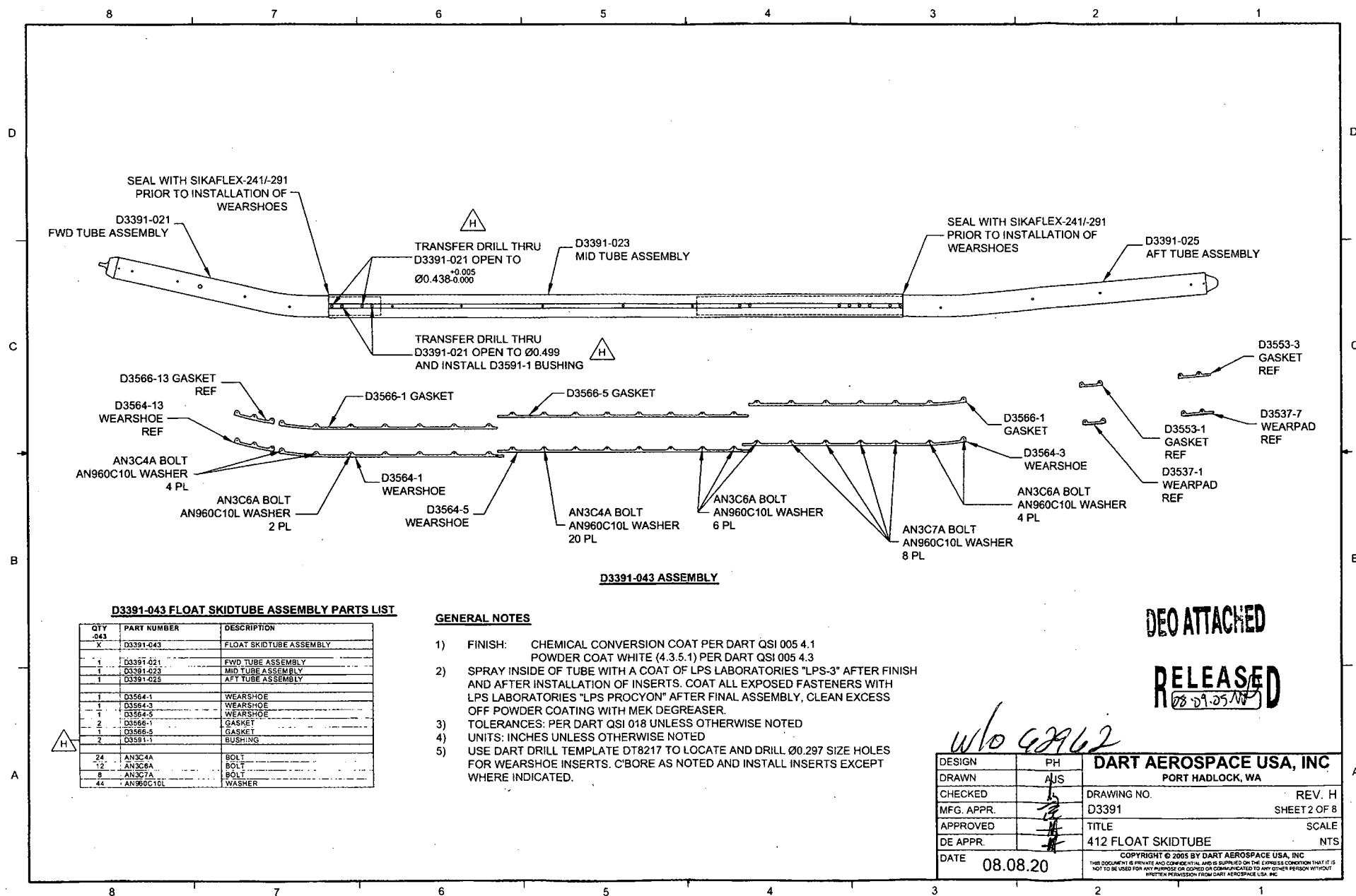
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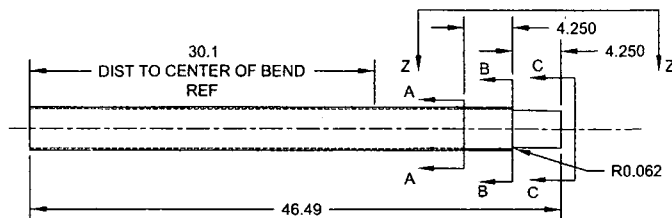
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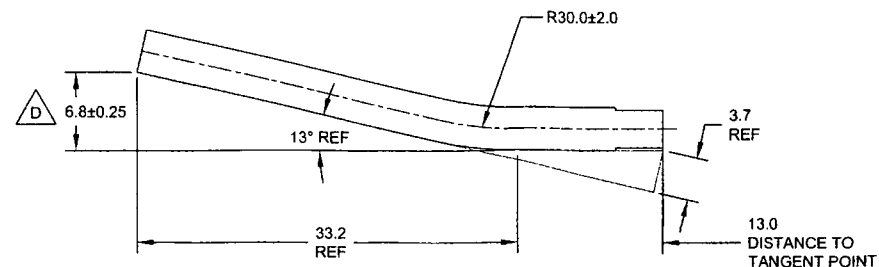
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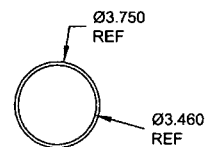
NOTE: Date & initial all entries



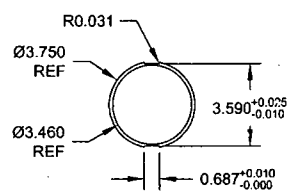
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



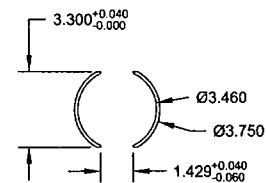
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



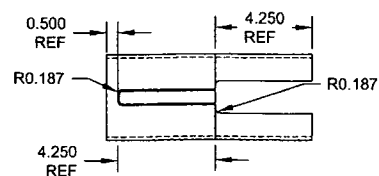
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X







SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

DEO ATTACHED
RELEASED
08-05-01

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

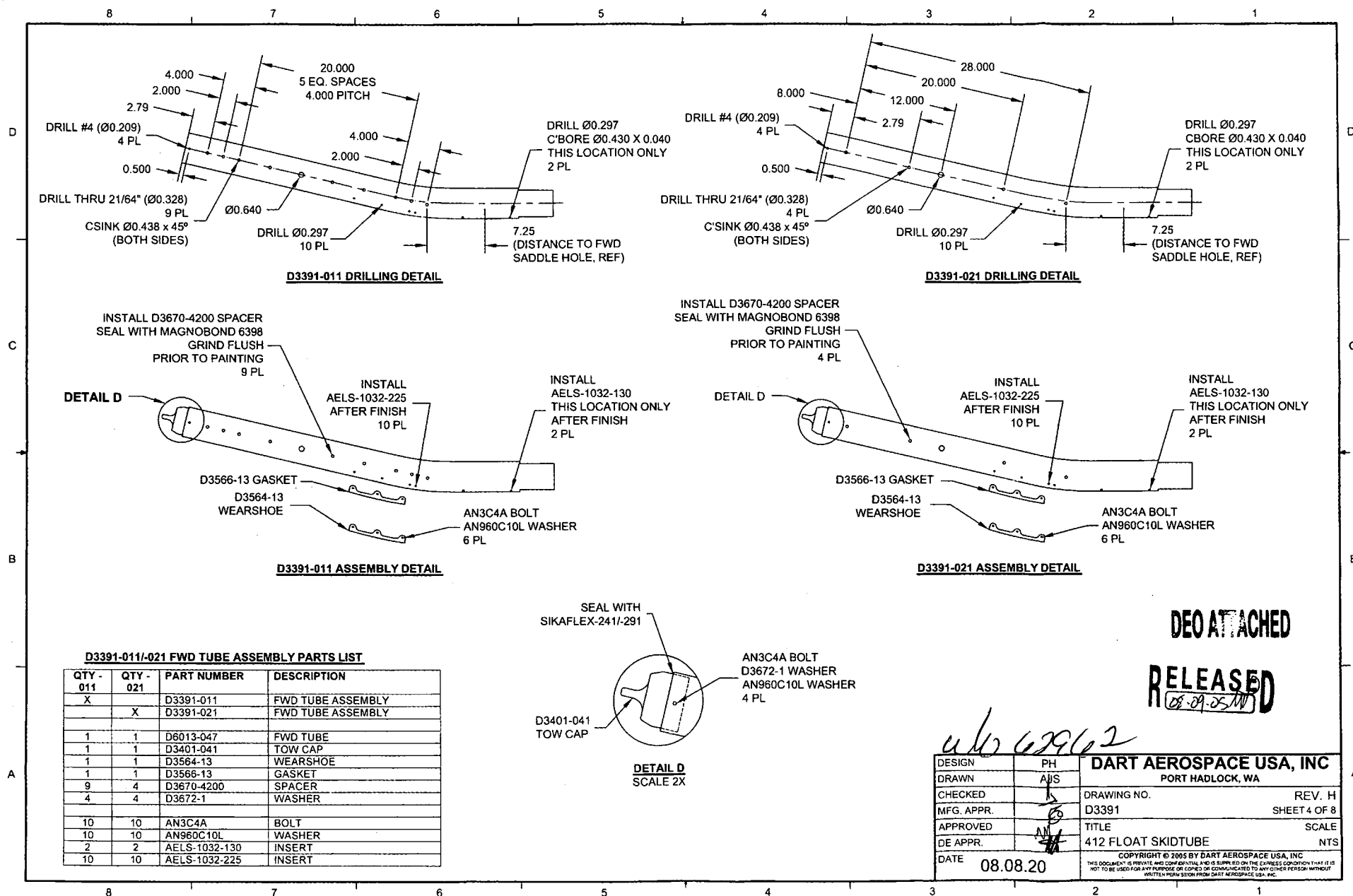
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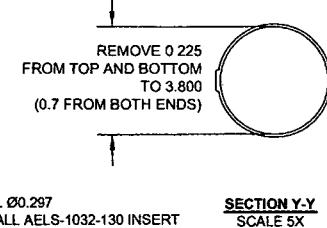
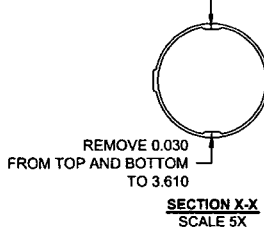
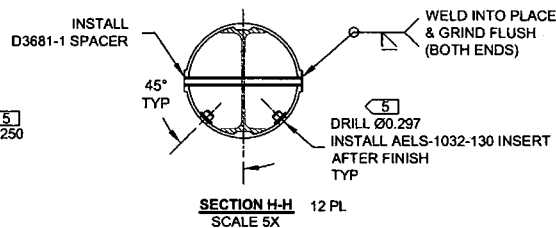
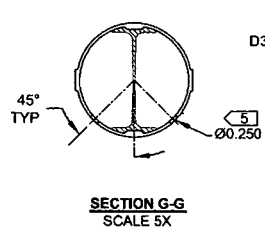
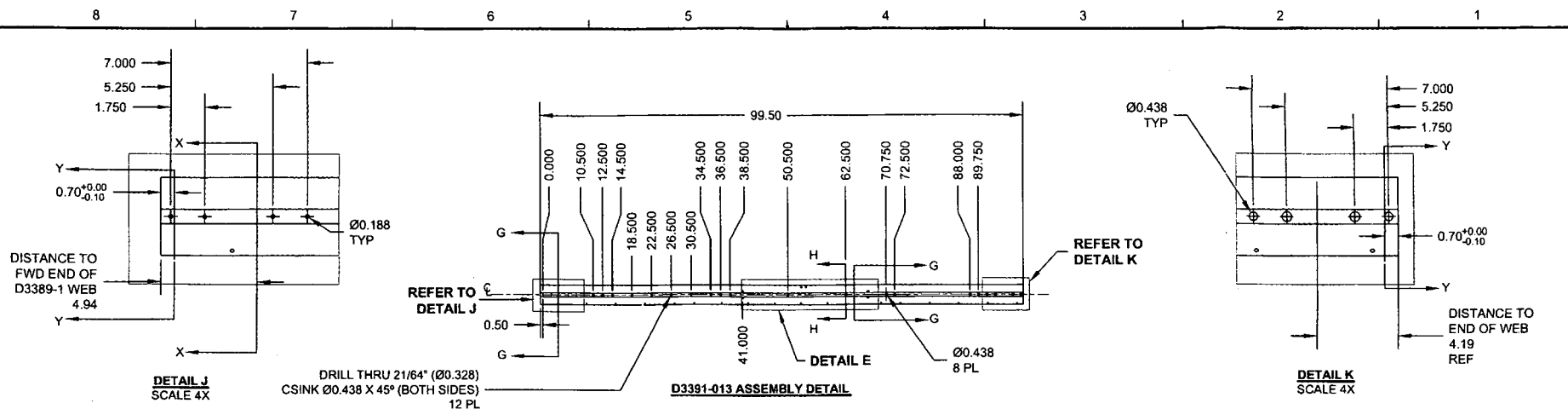
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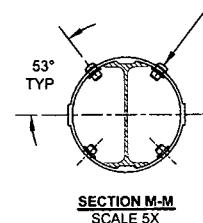
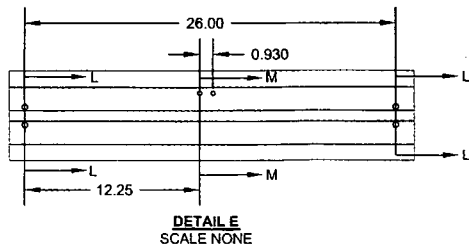
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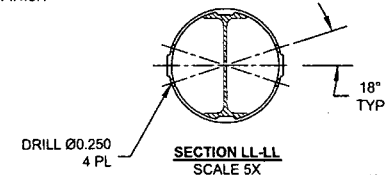


D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

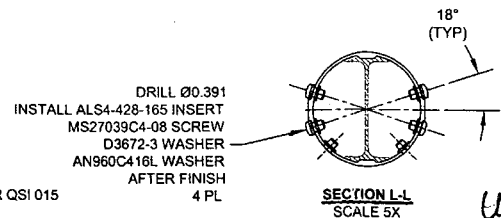


DRILL 0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



DEO ATTACHED
RELEASED

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AUS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 5 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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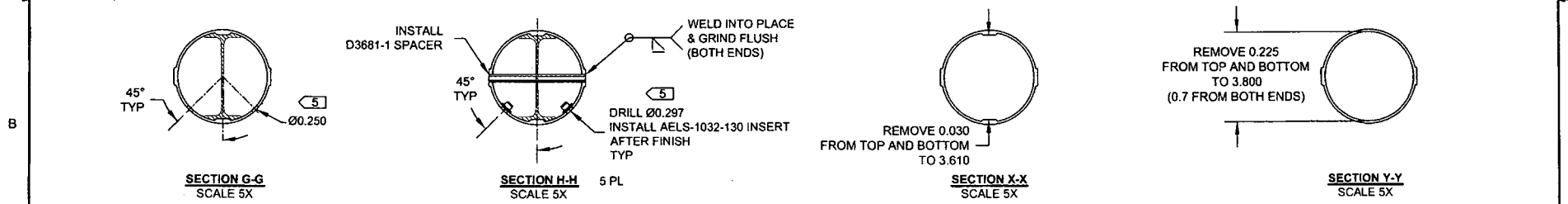
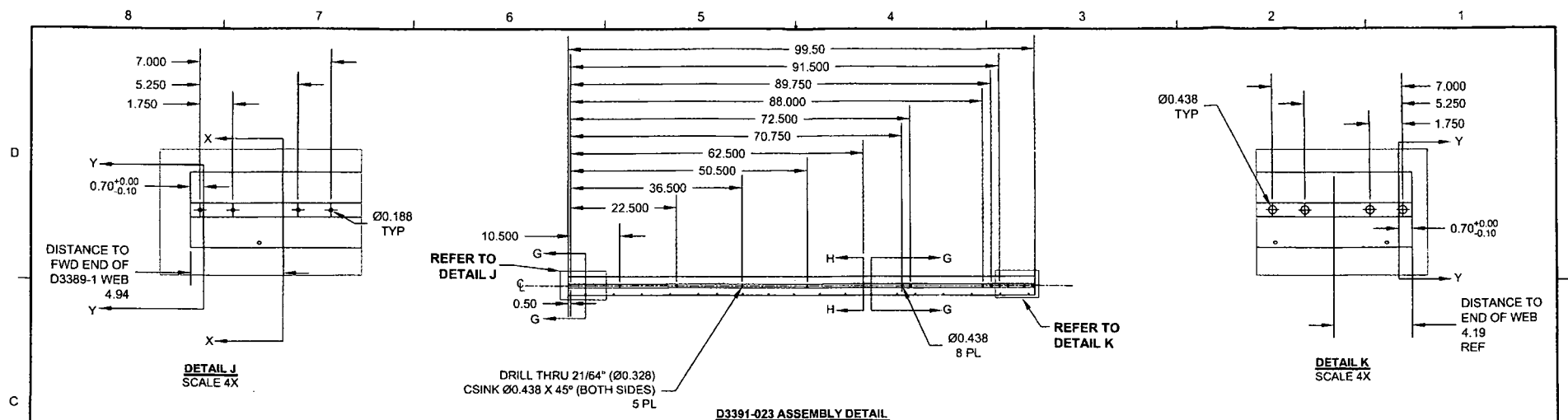
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DEO ATTACHED
RELEASED
08-09-25-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

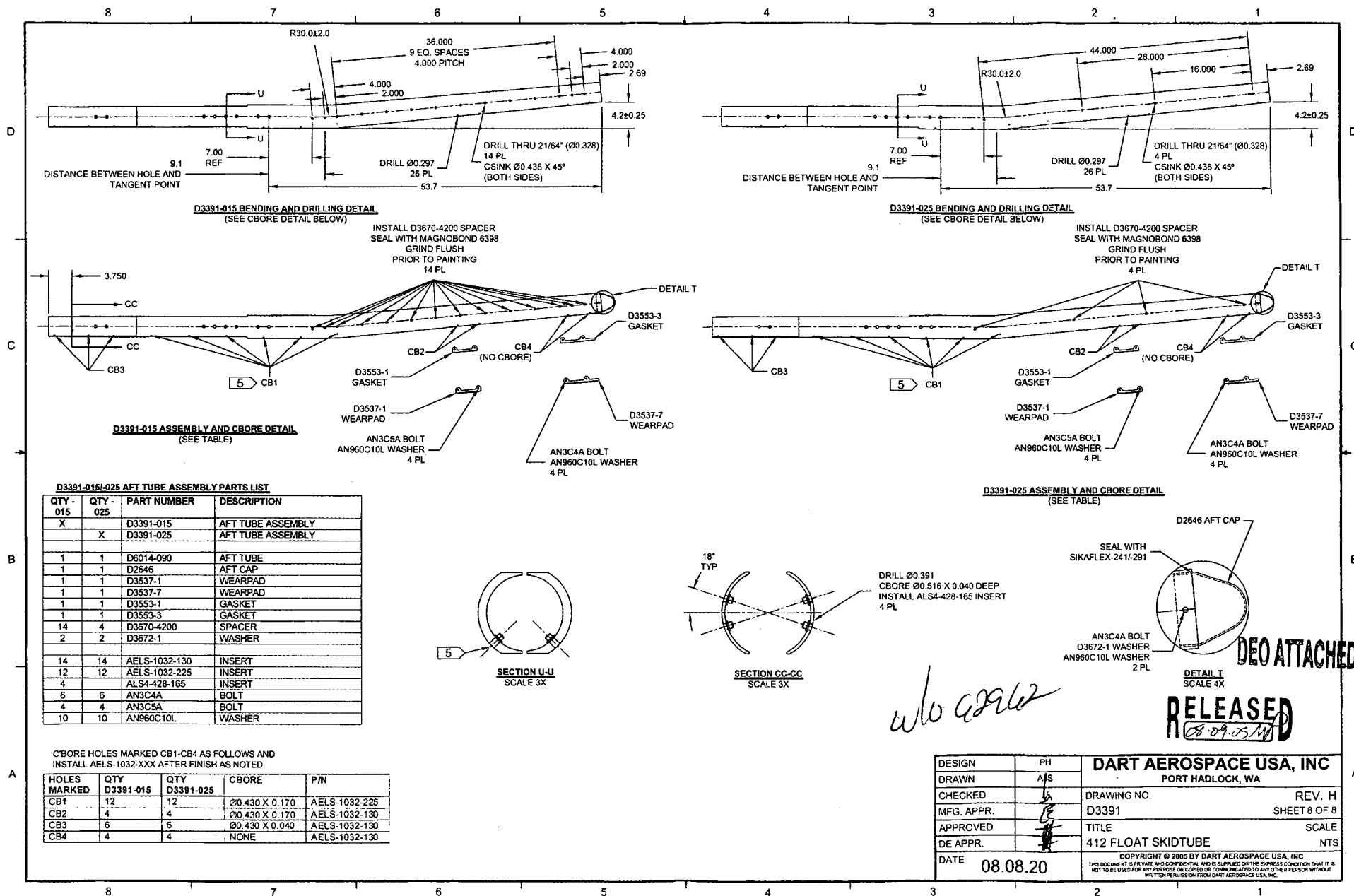
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>	DE APPR. <i>h</i>			
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30			

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

WLO 62962

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries